

Date: \* Thursday, 10/04/2008 4:00:33 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer:</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FWD X-TUBE
<b>Job Number</b>	: 38534		
<b>Estimate Number</b>	: 10006		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2889
<b>This Issue</b>	: 10/04/2008	<b>S.O. No. :</b>	
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2889 REV B
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 38424	<b>Drawing Revision</b>	: B
	<b>Type</b> : LANDING GEAR	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/04/2008
<b>Checked &amp; Approved By</b>	: <u>JD</u> <u>08.4.10</u>	<b>Qty:</b>	1 <b>Um:</b> Each
<b>Comment</b>	: Est Rev:A New Issue 05-10-25 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0 D6005180



**Comment:** Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Crosstube material

Pick:

Qty Part number Description Batch

1 D2889 Fwd Crosstube

034687

EL-8-424

2.0 BENDING

BENDING MACHINE - SKIDTUBES

**Comment:** LANDING GEAR RESOURCE 1

1-Bend D2889 as per Dwg D2889 and Folio FT001

EL 8-424

3.0 SKIDTUBES 1

SKIDTUBESS RESOURCE 1

**Comment:** LANDING GEAR RESOURCE 1

1-Deburr and Polish

u/4 used on w/p #38630

4.0 QC15

DIMENSIONAL CHECK OF X-TUBES

**Comment:** DIMENSIONAL CHECK OF X-TUBES

o/c 02/06/24 (u)

5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1

**Comment:** HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1

Inside and outside of tube

u/4 used on w/p #38630

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/04/2008 4:00:33 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 38534

Part Number: D2889

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

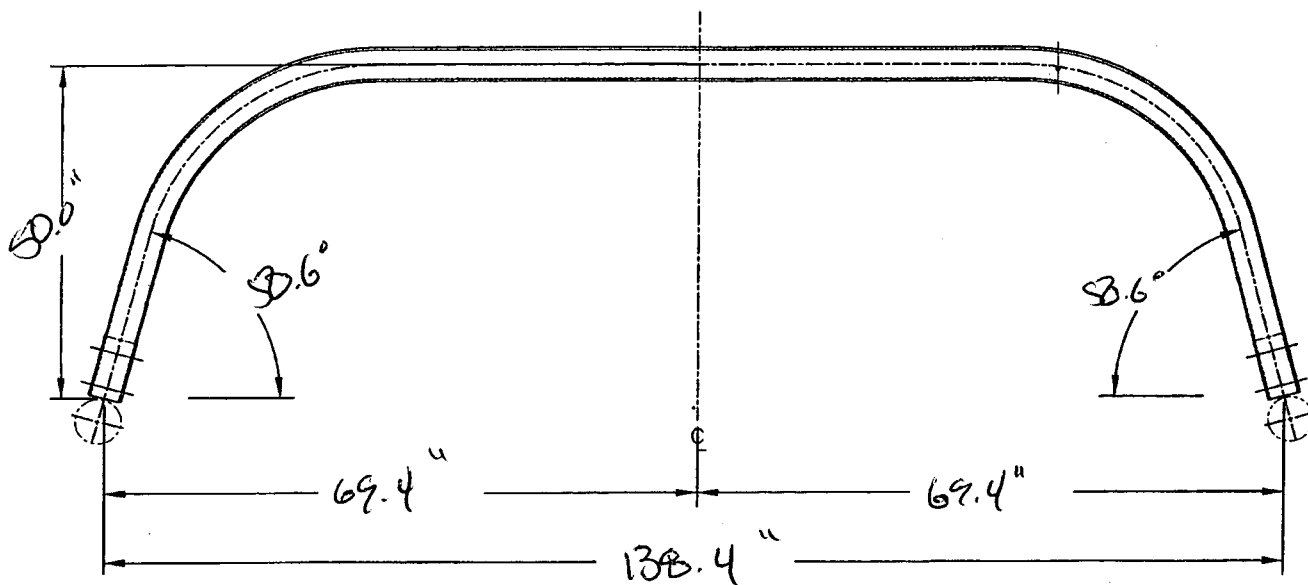
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	38534
Description: Crosstube Fwd		Part Number:	D2889
Inspection Dwg: D2889		Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
* used on w/o 38630

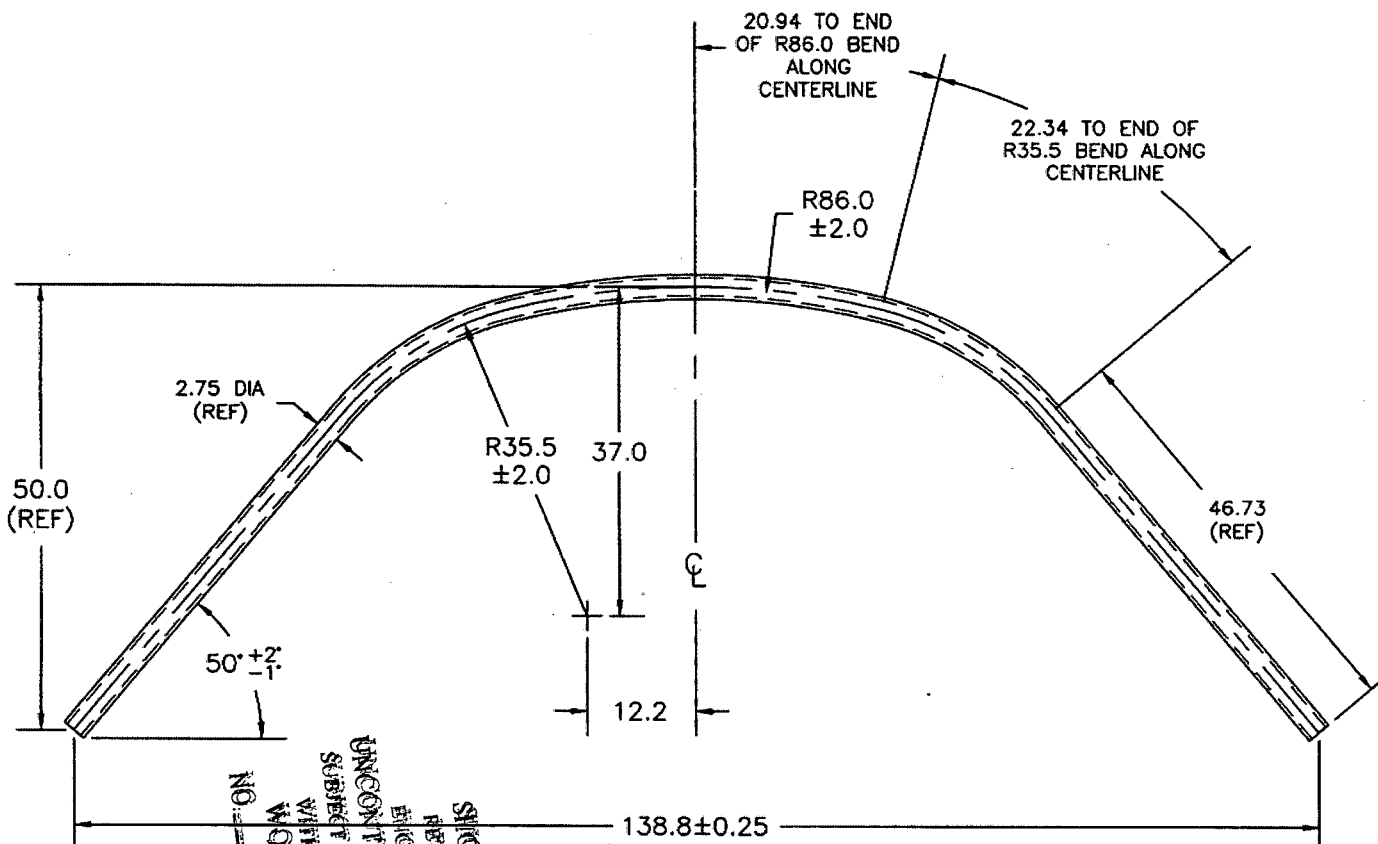
QC15 Inspection	
Date	08/04/24

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



RELEASED  
02.10.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
#		CP		HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. B
				D2889	SHEET 1 OF 1
DATE				TITLE	SCALE
02.10.18				FWD CROSS TUBE	1:20
A		99.05.21		NEW ISSUE	
B		02.10.18		ADD TANGENT LENGTHS, CHANGE NOTES	



#### NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 (ø2.75 OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.